

# Part Layout Dimensional Report

Customer: ABC COMPANY				Units: MM				Job Number: 09-12345			
Address: GUELPH				Environment: 20°C ± 2°C				Uncertainty: ±(3.0 + 10.1)µm X L			
Part Number: 1234567891				Revision: A				Inspection Date: 04/10/2008			
Part Name: ABCDEFG				CMM: 1808M				Issue Date: 4/15/09			
Procedure: 1234567891				Cavity:				Programmed By: AMCB			
Specification: As per customer CAD &/or Drawing.				Lot:				Inspected By: AMCB			

Axis	Nominal	+ Tol	- Tol	Sample: 01	Sample: 02	Sample: 03	Sample: 04	Sample: 05	Sample: 06	Max Dev	Mean Dev	Range	Out By	OK	Reject
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### Section A-A

#### FLATNESS 0.15 OF -A- (ITEM 12)

##### DIM FLT1 = FLATNESS OF PLANE PLN\_A

M		0.15		0.053	0.035	0.064	0.044	0.047	0.056	0.064	0.050	0.029			6
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#### 6.2/6.0 DIA. (ITEM 10) TP 0.2s|A|Bs| (ITEM 4)

##### DIM LOC13= TRUE POSITION OF CIRCLE MIDC1\_GEN

X	0.000			-0.021	0.082	0.017	0.001	0.035	0.005	0.082	0.020	0.103			6
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Y	0.000			-0.085	-0.091	-0.001	-0.113	-0.033	-0.108	-0.113	-0.072	0.112			6
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DF	6.000	0.200	0.000	6.057	6.049	6.039	6.034	6.043	6.042	0.057	0.044	0.023			6
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TP		0.2	A B C	0.170	0.182	0.002	0.126	0.066	0.116	0.182	0.110	0.180			6
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#### PROFILE 3.0 |A|B|C| (ITEM 2)

##### Total Profile (Worst Case)

T		3.0	A B C	0.564	0.487	0.538	0.562	0.611	0.539	0.611	0.550	0.124			6
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				Total Profile	1.128	0.974	1.076	1.124	1.222	1.078					
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#### DIM D23= LOCATION OF POINT FRM2

X	4256.928			4256.434	4256.441	4256.390	4256.368	4256.492	4256.403	-0.560	-0.507	0.124			6
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Y	-583.074			-583.074	-583.074	-583.074	-583.074	-583.074	-583.074	0.000	0.000	0.000			6
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Z	132.965			132.965	132.965	132.965	132.965	132.965	132.965	0.000	0.000	0.000			6
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T		3.0	A B C	0.494	0.487	0.538	0.560	0.436	0.525	0.560	0.507	0.124			6
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				Total Profile	0.988	0.974	1.076	1.120	0.872	1.050					
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#### DIM D24= LOCATION OF POINT FRM3

X	4256.928			4256.445	4256.448	4256.409	4256.366	4256.498	4256.415	-0.562	-0.498	0.132			6
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Y	-576.591			-576.591	-576.591	-576.591	-576.591	-576.591	-576.591	0.000	0.000	0.000			6
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Z	156.329			156.329	156.329	156.329	156.329	156.329	156.329	0.000	0.000	0.000			6
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T		3.0	A B C	0.483	0.480	0.519	0.562	0.430	0.513	0.562	0.498	0.132			6
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				Total Profile	0.966	0.960	1.038	1.124	0.860	1.026					
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#### DIM D27= LOCATION OF POINT FRM9

X	4313.803			4313.803	4313.803	4313.803	4313.803	4313.803	4313.803	0.000	0.000	0.000			6
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Y	-583.521			-583.521	-583.521	-583.521	-583.521	-583.521	-583.521	0.000	0.000	0.000			6
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Z	162.606			162.642	162.647	162.651	162.629	162.657	162.685	0.079	0.046	0.056			6
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T		3.0	A B C	0.036	0.041	0.045	0.023	0.051	0.079	0.079	0.046	0.056			6
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				Total Profile	0.072	0.082	0.090	0.046	0.102	0.158					
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#### DIM D28= LOCATION OF POINT FRM4

X	4331.928			4332.492	4332.401	4332.421	4332.351	4332.539	4332.467	0.611	0.517	0.188			6
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Y	-554.673			-554.673	-554.673	-554.673	-554.673	-554.673	-554.673	0.000	0.000	0.000			6
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Z	126.743			126.743	126.743	126.743	126.743	126.743	126.743	0.000	0.000	0.000			6
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T		3.0	A B C	0.564	0.473	0.493	0.423	0.611	0.539	0.611	0.517	0.188			6
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				Total Profile	1.128	0.946	0.986	0.846	1.222	1.078					
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#### 3.75/3.55 DIM. (ITEM 8)

##### DIM LOC16= LOCATION OF POINT IT59

X	-3.750	0.200	0.000	-3.738	-3.610	-3.733	-3.637	-3.658	-3.747	0.140	0.063	0.137			6
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#### 6.6/6.4 DIM. (ITEM 9)

##### DIM LOC20= LOCATION OF POINT IT66

X	6.600	0.000	0.200	6.400	6.576	6.455	6.581	6.418	6.508	-0.200	-0.110	0.181			6
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#### 7.0/6.7 DIM. (ITEM 7)

##### DIM LOC1= LOCATION OF POINT IT68

X	-6.850	0.150	0.150	-6.669	-6.679	-6.655	-6.687	-6.715	-6.609	0.241	0.181	0.106	0.091	1	5
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### Section B-B

#### 14.0/13.8 DIA. (ITEM 1) TP 0.2m|A|Bs| (ITEM 3)

##### DIM LOC3= TRUE POSITION OF CIRCLE IT44

Y	0.000			-0.021	0.047	-0.017	0.001	-0.015	0.005	0.047	0.000	0.068			6
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Z	0.000			-0.017	-0.012	-0.013	-0.013	-0.018	-0.012	-0.018	-0.014	0.006			6
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DF	13.900	0.100	0.100	13.950	13.958	13.940	13.939	13.941	13.942	0.058	0.045	0.019			6
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TP		0.2	A B C	0.054	0.096	0.043	0.026	0.047	0.027	0.096	0.049	0.070			6
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				Bonus	0.050	0.042	0.060	0.061	0.059	0.058					
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## Part Layout Dimensional Report

Part Number: 1234567891				Revision: A				Inspection Date: 04/10/2008							
Part Name: ABCDEFG				Cavity:				Job Number: 09-12345							
Axis	Nominal	+ Tol	- Tol	Sample: 01	Sample: 02	Sample: 03	Sample: 04	Sample: 05	Sample: 06	Max Dev	Mean Dev	Range	Out By	OK	Reject
23.05/22.85 DIA. (ITEM 5) TP 0.2m A Bs  (ITEM 6)															
DIM LOC4= TRUE POSITION OF CIRCLE IT85															
Y	0.000			0.061	0.082	0.024	0.013	0.035	-0.008	0.082	0.035	0.090			6
Z	0.000			0.026	0.006	0.006	0.007	0.027	0.003	0.027	0.013	0.024			6
DF	22.950	0.100	0.100	23.037	22.880	22.958	22.868	22.999	22.856	-0.094	-0.017	0.181			6
TP	⊕ 0.2Ⓜ A B Ⓢ			0.133	0.165	0.050	0.029	0.088	0.017	0.165	0.080	0.148			6
			Bonus	0.013	0.170	0.092	0.182	0.051	0.194						
30° ANGLE (ITEM 11)															
DIM ANG4 = 2D ANGLE FROM LINE IT54_LN TO ZAXIS															
A	30.000	1.000	1.000	30.721	30.932	30.879	30.719	30.863	30.804	0.932	0.820	0.213			6
15.50/15.30 DIM. (ITEM 14) 4 PLACES															
DIM DIS19 = 2D DISTANCE FROM LINE LN87_2 TO LINE LN87_6 PARALLEL TO ZAXIS, NO_RADIUS															
M	15.400	0.100	0.100	15.328	15.366	15.321	15.377	15.347	15.305	-0.095	-0.059	0.072			6
DIM DIS16 = 2D DISTANCE FROM LINE LN87_5 TO LINE LN87_1 PARALLEL TO ZAXIS, NO_RADIUS															
M	15.400	0.100	0.100	15.330	15.370	15.336	15.326	15.324	15.386	-0.076	-0.055	0.062			6
DIM DIS17 = 2D DISTANCE FROM LINE LN87_3 TO LINE LN87_7 PARALLEL TO YAXIS, NO_RADIUS															
M	15.400	0.100	0.100	15.314	15.384	15.325	15.346	15.381	15.355	-0.086	-0.049	0.070			6
DIM DIS18 = 2D DISTANCE FROM LINE LN87_4 TO LINE LN87_8 PARALLEL TO YAXIS, NO_RADIUS															
M	15.400	0.100	0.100	15.302	15.393	15.316	15.349	15.377	15.360	-0.098	-0.050	0.091			6
ANGULARITY 0.15 C  (ITEM 15) 4 PLACES															
DIM AGL13 = ANGULARITY FROM LINE LN87_5_1 TO PLANE PLN88_1 EXTENDLENGTH=0.00															
M	∠ 0.15 C			0.024	0.006	0.014	0.017	0.012	0.011	0.024	0.014	0.018			6
DIM AGL5 = ANGULARITY FROM LINE LN87_3_7 TO PLANE PLN88_1 EXTENDLENGTH=0.00															
M	∠ 0.15 C			0.027	0.007	0.013	0.015	0.020	0.006	0.027	0.015	0.021			6
DIM AGL2 = ANGULARITY FROM LINE LN87_2_6 TO PLANE PLN88_2 EXTENDLENGTH=0.00															
M	∠ 0.15 C			0.015	0.008	0.003	0.021	0.009	0.008	0.021	0.011	0.018			6
DIM AGL4 = ANGULARITY FROM LINE LN87_4_8 TO PLANE PLN88_2 EXTENDLENGTH=0.00															
M	∠ 0.15 C			0.018	0.008	0.008	0.017	0.010	0.011	0.018	0.012	0.010			6

The results relate only to the items inspected.

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